

Work Order ID 95153

95153

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Monday, January 14, 2013 7:49:17 AM

Item ID:	D3196-1	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					Stop	*NS2*
Item Name:	Bar					
Start Date:	1/2/2013	Start Qty: 5.00	*5*	Cust Item ID:		
Required Date:	1/18/2013	Req'd Qty: 5.00	*5*	Customer:		
Reference:	<i>13.01.14</i>					
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3196	Rev C								
100	BAND SAW	0.00				<u>5</u>	<u>0</u>		
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank: (0.75" x 1.50") x 26.200" long Bar			<i>OK 13/01/15</i>					
110	HAAS CNC VERTICAL MACHINING #1	0.00				<u>5</u>	<u>0</u>		<i>DAS 08 9-89</i>
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine D3196-1 as per Folio FA339 and Dwg D3196Identify as D3196-12-Deburr			<i>B.A 13/01/17</i>					
120	QC2- Inspect parts off machine FAI/FAIB	0.00				<u>5</u>	<u>0</u>		<i>DAS 08 9-89</i>
120									
QC	Memo	0.00							
Quality Control				<i>B.A 13/01/17</i>					

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Item ID: D3196-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bar
Start Date: 1/2/2013 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 1/18/2013 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>OK 13/01/21</i>		<u>5</u>	<u>5</u>		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>5</u>	<u>16 13-1-22</u>		
150 *150* Powdercoat Powder Coating	Grey Sandtex (Ref 4.3.5.6) per QSI005 4.3 <i>NR2966</i> Memo START TIME: <u>2:55</u> <u>000</u> FINISH TIME: <u>3:25</u>	0.00 0.00				<u>5</u>	<u>16 13-1-24</u>		

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Item ID: D3196-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bar
Start Date: 1/2/2013 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 1/18/2013 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				5	φ	M 13/01/21	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST259</u> Memo	0.00 0.00				5		13-01-25AB	
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						13/1/28	

130125

Picklist Print

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Work Order ID: 95153

Parent Item: D3196-1

Parent Item Name: Bar

Start Date: 1/2/2013

Required Date: 1/18/2013

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev: A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.500 6061-T6 Bar .750 X 1.50		Purchased	No			100	f	53.7907	2.183	11.489474			

Location
~~MAT049~~
 MAT02 → 121040
 122521
 122753

Loc Qty
 53.7907302
 25.147368
 4.6433622
 24

Loc Code

11.49 OK 13/01/15

DART AEROSPACE LTD		Work Order:	
Description: Bar		Part Number:	D3196-1
Inspection Dwg: D3196 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.094	+/-0.010	26.094	✓		Edge Finder	HAAS-4
4.045	+/-0.010	4.044	✓		Vern	GA-01
18.003	+/-0.005	18.003	✓		Edge finder	HAAS-4
0.750	+/-0.005	0.756	✓		Vern	GA-01
1.500	+/-0.010	1.503	✓		"	"
Ø0.344	+0.006/-0.001	Ø0.344	✓		Vern	CNC-02
Ø0.660 x 100°	+0.008/-0.001 x 0.5°	Ø0.660 x 100°	✓		"	"
0.060 x 45°	+/-0.010 x 0.5°	0.055 x 45°	✓		"	"
0.750	+/-0.010	0.746	✓		"	"
0.250	+/-0.010	0.249	✓		Vern	GA-01
3.495	+/-0.010	3.492	✓		"	"
9.000	+/-0.010	9.002	✓		Vern	CNC-02
16.844	+/-0.010	16.842	✓		H-G	31006
21.498	+/-0.010	21.496	✓		"	"
R0.125	+/-0.010	R0.125	✓		R-6	ref.
1.1 00	+/-0.010	1.099	✓		Vern	GA-01
R0.125	+/-0.010	R0.125	✓		R-6	ref.
0.444	+/-0.010	0.442	✓		Vern	CNC-02

Measured by: D.A. 08	Audited by: [Signature]	Prototype Approval:	N/A
Date: 13/01/17	Date: 13/01/21	Date:	N/A

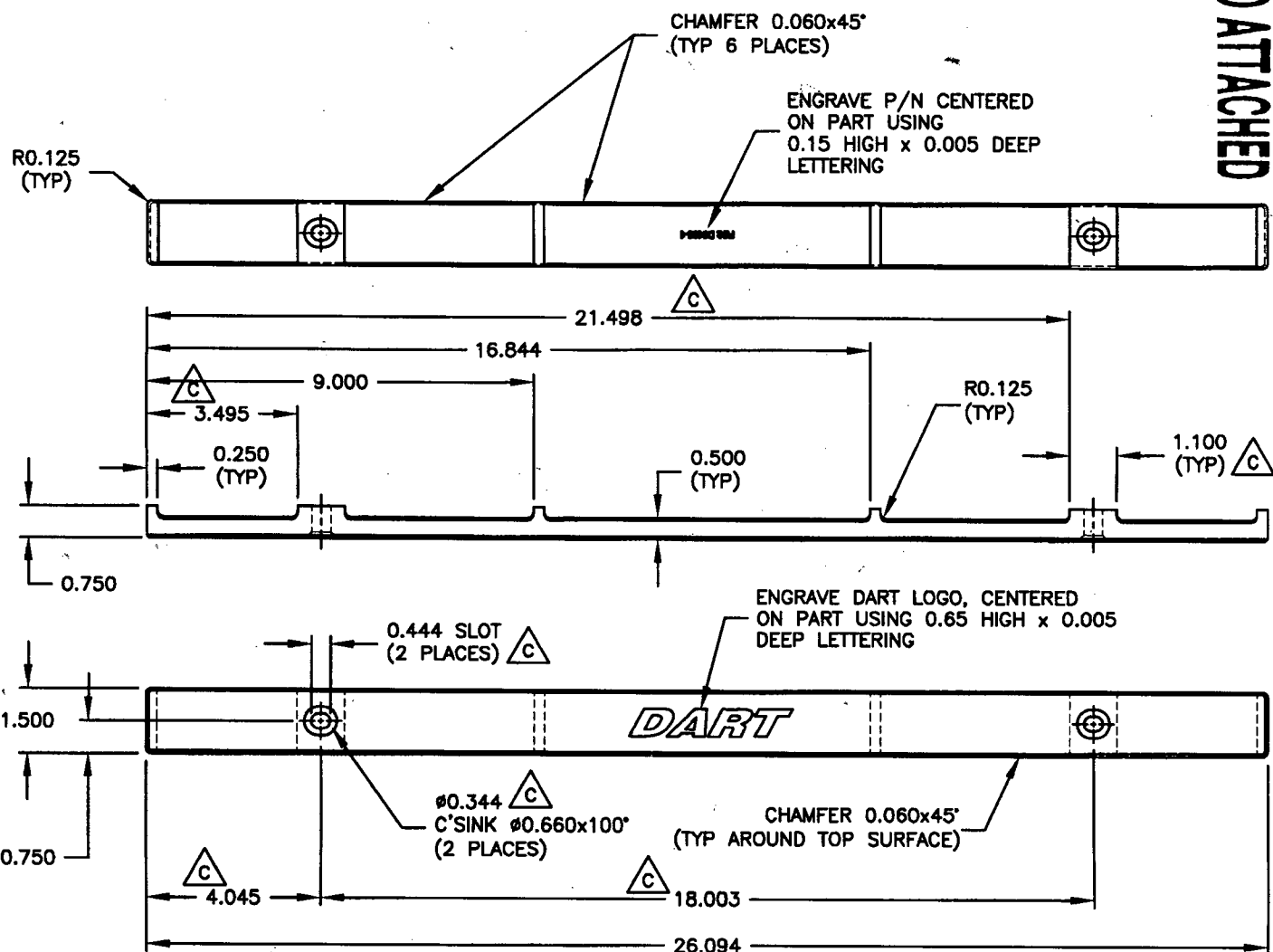
Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.10.24	Dwg Rev. updated	KJ/JLM	
C	07.03.21	Dimensions updated per Dwg rev. C	KJ/JLM [Signature]	[Signature]

DART

RELEASED

06.10.31

DEO ATTACHED



D3196-1 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
40	J.B.	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PH	J.B.	D3196
DATE	TITLE	REV. C
06.10.31	BAR	1 OF 3
A	03.06.25	NEW ISSUE
B	06.09.25	ADD D3196-5
C	06.10.31	ADD SLOTS ON -1; REMOVED -5
SCALE		1:4